



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

500-302051-001
Job Sheet 213053



URGENT

Part No: 500-302051-001

Job Qty: 3 ea

Part Name: Pin, Strut Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/15/20

Job Tracking No:

Due Date: 9/24/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 500-302051 REV IR IPP REV:A NEW ISSUE 20-06-09 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL-154 - 1	3 pcs	9/17/20		0.50	1.00	Doosan - 1		<i>JB 20-09-15</i>
							NLX 2500SY - 1		
							SL-154 - 1		
							SL-2500Y - 1		
110	QC 2	3 pcs	9/17/20		0.00	0.00	QC 2 - 1		<i>JB 20-09-15</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S300483



Part: 500-302051-001

Job No: 213053

Serial No/Batch: S300483

Revision: REV IR

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/15/20

Plex 9/15/20 11:42 AM Dart.lajeunesse.marie

				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	3 pcs	9/17/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Outsource - 6 - Polish	3 pcs	9/24/20		GRO002-VC 5
135	Packaging 2-1 - Receive - B4B	3 pcs	9/24/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B

D.E 20-09-16

SEP 17 2020

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21
9-09

				Packaging 2 - 19 - B4B			
				Packaging 2 - 20 - B4B			
				Packaging 2 - 21 - B4B			
				Packaging 2 - 22 - B4B			
				Packaging 2 - 23 - B4B			
				Packaging 2 - 24 - B4B			
				Packaging 2 - 25 - B4B			
				Packaging 2 - 26 - B4B	DAS		
				Packaging 2 - 27 - B4B	21		
				Packaging 2 - 28 - B4B	9-89 SEP 17 2020		
				Packaging 2 - 29 - B4B			
				Packaging 2 - 30 - B4B			
				Packaging 2 - 31 - B4B			
				Packaging 2 - 32 - B4B			
				Packaging 2 - 33 - B4B			
				Packaging 2 - 34 - B4B			
				Packaging 2 - 35 - B4B			
				Packaging 2 - 36 - B4B			
				Packaging 2 - 37 - B4B			
140	QC 6	3 pcs	9/24/20	0.00 0.00	QC 6 - 9	DAS	
				0.00 0.00	QC 6 - 68	21	
					QC 6 - 61	9-89	
					QC 6 - 40		
					QC 6 - 81	SEP 17 2020	
					QC 6 - 82		
150	Packaging 3-1 - Stock - B4B	3 pcs	9/24/20	0.00 0.00	Packaging 3 - 1 - B4B		
				0.00 0.00	Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B	DAS	
					Packaging 3 - 6 - B4B	28	
					Packaging 3 - 7 - B4B	9-89	
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B	SEP 17 2020	
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		
					Packaging 3 - 32 - B4B		
					Packaging 3 - 33 - B4B		
					Packaging 3 - 34 - B4B		
				Plex 9/15/20 11:42 AM Dart.lajeunesse.marie			

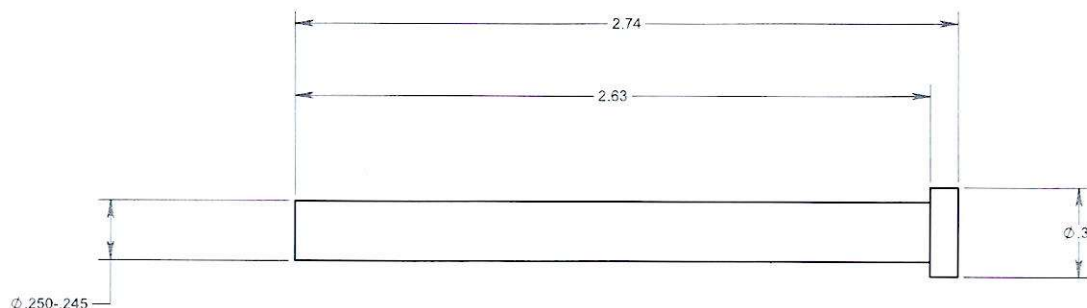
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160	QC21-SA	3 Ea	9/24/20	0.00 0.00	QC 21 - SA - 21
					DAS 21 SEP 17 2020
Part Op 100 - Verify material spec with QC Turn as per dwg 500-302051 1-Machine as per folio FD308 F080 REV: Descriptions: AA DWG REV: IR 2-Deburr 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - ISSUE PO: Electropolish as per ASTM B912 Material: AISI 17-4PH H1150 -Certificate of Conformity is required 135 - Receive & Inspect for Damage & Mat'l Certs 140 - QC6- All purchased or subcontracted products 150 - Identify as per dwg & Stock 160 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M17-4-H1150-R0.625	17-4 SS Round Bar H1150 0.625" dia.	.7200 ft (.24 ea)	100-SL-154 - 1	S298101	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-SL-154 - 1	M17-4-H1150-R0.625	1	13	0	
Part Specifications					
Specifications could not be found.					

GA-TBD

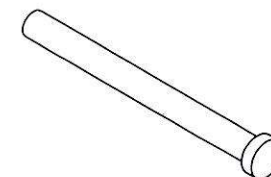
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NEXT ASSEMBLY		PROJECT		REVISIONS			
500-302000-301		500 VARIOUS		REV.	DESCRIPTION	REV BY	DATE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 213053 MJS
20-09-15



500-302051-001,
PIN, STRUT MOUNT

NOTE:

- HEAT TREAT TO CONDITION H1150 IAW AMS2759/3.
MINIMUM HARDNESS HB 277-352 (HRC 28-37).
NO ADDITIONAL TENSILE TESTS REQUIRED IF THE MATERIAL
CERTIFICATION QUALIFIES THROUGH TEST THAT THE MATERIAL
CAPABILITY MEETS THE MINIMUM PERFORMANCE REQUIREMENTS
PER AMS 5604/5643 AT THE H900 CONDITION.

- DO NOT SCALE DRAWING - UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES REMOVE ALL BURRS & BREAK SHARP EDGES				SIGNATURE DATE		SIMPLEX Aviation Mission Equipment 13340 N.E. Whitaker Way Portland, Oregon 97230 Ph. 503.257.3511	
TOLERANCES DIMENSIONS X.X ± .1 X.XXX ± .005 ANGLES X ± 1° X.X ± .5°				PROJECTION PRODUCTION CONTROL DATE		TITLE PIN, STRUT MOUNT	
MATERIAL AISI 17-4PH, H1150, PER AMS 5643				ESTIMATED WEIGHT 0.005 Lbs		DRAWING NO. 500-302051	
FINISH ELECTROPOLISH PER ASTM B912				DRAWING FILE NAME 500-302051		REV IR	
SCALE 1:1				MODEL FILE NAME 500-302051		SHEET 1 OF 1	

ET-001-A

Work Order:	213053
Part Number:	500-302051-001
	Page 1 of 1

[illegible]

Measured by: JB	9-89	Checked by: B.A.	QC Inspector:	82 9-89
Date: 20-09-15		Date: 20-09-16	Date:	SEP 22 2020

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	15-Sep-20	New Issue	MG	

S/N 5300483

DAS
82
9-89

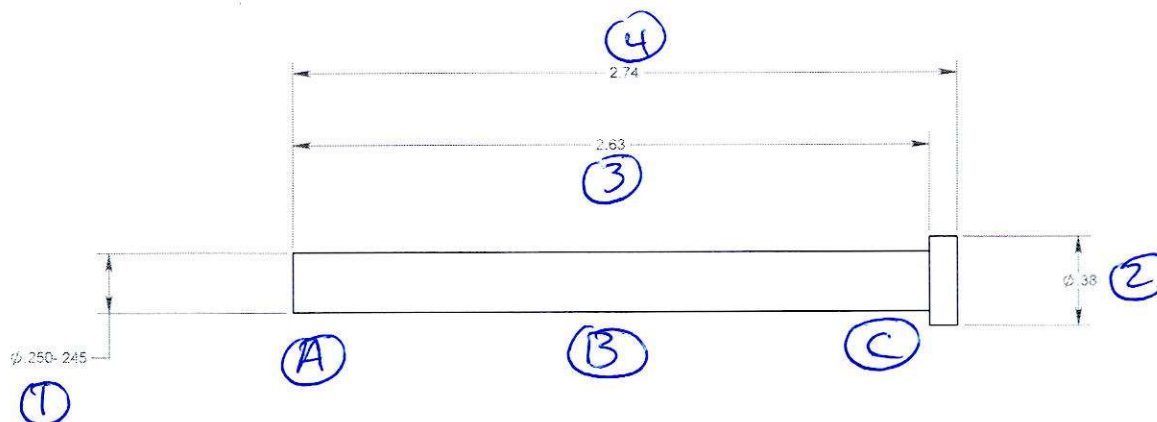
SEP 18 2020

Date:

Approved

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PROHIBITED.

NEXT ASSEMBLY	PROJECT	REVISIONS			
500-302000-301	500 VARIOUS	REV.	DESCRIPTION	REV BY	DATE APPV



NOTE:

- ① HEAT TREAT TO CONDITION H1150 IAW AMS2759/3.
MINIMUM HARDNESS HB 277-352 (HRC 28-37). ②
NO ADDITIONAL TENSILE TESTS REQUIRED IF THE MATERIAL
CERTIFICATION QUALIFIES THROUGH TEST THAT THE MATERIAL
CAPABILITY MEETS THE MINIMUM PERFORMANCE REQUIREMENTS
PER AMS 5604/5643 AT THE H900 CONDITION.

- DO NOT SCALE DRAWING - UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES REMOVE ALL BURRS & BREAK SHARP EDGES		SIGNATURE	DATE	 13340 N.E. Whitaker Way Portland, Oregon 97230 Ph. 503.257.3511
TOLERANCES		CHECKED BY	DATE	
DIMENSIONS: XX ± .1 XXX ± .01 XXXX ± .005 ANGLES: X ± 1° XX ± 5°		D KRUTHOFF	8/1/13	
PROJECTION 		D WRIGHT	2/12/14	
MATERIAL		PRODUCTION CONTROL	DATE	TITLE
⑤ AISI 17-4PH, H1150, PER AMS 5643		J RODRIGUEZ	2/11/14	PIN, STRUT MOUNT
FINISH		DESIGNED BY	DATE	DRAWING NO.
⑥ ELECTROPOLISH PER ASTM B912		D CORNELIUS	2/12/14	500-302051
DRAWING FILE NAME		ESTIMATED WEIGHT	SIZE	REV
500-302051		0.005 Lbs	B	IR
SCALE		MODEL FILE NAME		SHEET 1 OF 1
1:1		500-302051		

top of hat
Mitutoyo SurfTest SJ-400

DATE 2000-01-30
TIME 05:34:48

STAND JIS2001
PROFILE R
FILTER GAUSS
EVA-L 0.16in
N 5
 λ_c 0.03in
 λ_s 100 μ in
TILT-COMP. ALL
CURVE-CMP. OFF
M-SPEED 0.02in/s
R-SPEED 0.04in/s
AUTO-RTN ON
RANGE 32000 μ in
 $\pm$ ESC
DRIVE ON
STYLUS STAND
PRE/POST ON

R-PROFILE

EVA-L 0.16in
 λ_c 0.03inX5

Ra 24.1 μ in
Rz 176 μ in
Rq 33.9 μ in

R-PROFILE

EVA-L 0.16in
 $\lambda_c=0.03inX5$

$\rightarrow \times 2K$
 $\downarrow$
 $\times 50$

Ver. 500.000 μ in/in
Hor. 0.020in /in



$\phi .245$

Mitutoyo SurfTest SJ-400

DATE 2000-01-30
TIME 05:37:29

STAND JIS2001
PROFILE R
FILTER GAUSS
EVA-L 0.5in
N 5
 λ_c 0.1in
 λ_s 320 μ in
TILT-COMP. ALL
CURVE-CMP. OFF
M-SPEED 0.02in/s
R-SPEED 0.04in/s
AUTO-RTN ON
RANGE 32000 μ in
 $\pm$ ESC
DRIVE ON
STYLUS STAND
PRE/POST ON

R-PROFILE

EVA-L 0.5in
 λ_c 0.1inX5

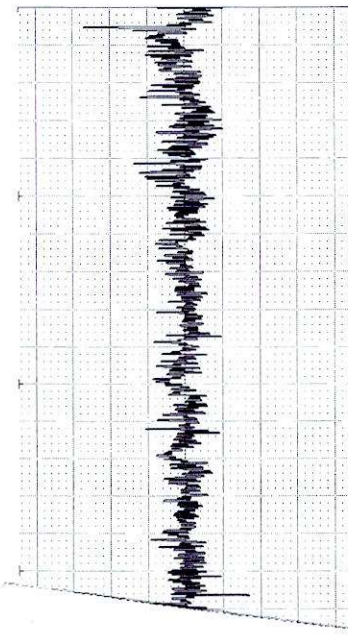
Ra 11.6 μ in
Rz 111 μ in
Rq 14.8 μ in

R-PROFILE

EVA-L 0.5in
 $\lambda_c=0.1inX5$

$\rightarrow \times 5K$
 $\downarrow$
 $\times 10$

Ver. 200.000 μ in/in
Hor. 0.100in /in



SCHMOLZ + BICKENBACH Providing special steel solutions				No. Production Order US03 2630198627 02/10/2017		Purchaser Murphy & Nolan Order No. 2650228548/10 02/06/2017		Customer PO: 210532-17 Delivery Note /Item /Of 2650228548/10 02/06/2017		Mill Cert.: 82039434-1 Inspection certificate 3.1 Acc. to EN 10204 No. 3000633489 /0002 From: 02/10/2017							
Ship to: Murphy & Nolan 3060 William St. Cheektowaga 14227 NY				Customer Standard: Industry Standard: UNS S17400, AISI 630, EN 10088-3 1.4542 <u>ASTM A564-13</u> Condition A, ASTM F899-12, ASTM A484-14, <u>AMS 5643T</u>								Shaila J. Di Nicola Quality Manager					
				Dimension A 0.6250 inch		Dimension B 0.0000 inch		Dimension C 144.0000 inch		Material No. 2068684							
Chemical composition in %																	
Heat-No.	C	Si	Mn	P	S	Cr	Ni	Mo	Cu	Nb							
639612	0,021	0,339	0,806	0,021	0,020	15,287	4,483	0,037	3,131	0,166							
Mechanical Properties												Magnetic Test		Additional Test			
Product / Steel making Process				Hardness		Tension Test				Impact Test							
Product: 630(17-4) UGIMA round - Solut. Treat., Cold Drawn - SMQ				Standard: ASTM A370		ASTM A370 Standard: Temperature: 7 1- 75				Temperature:							
Weight of Delivery	Job Information			HB	HRC	T	02Y	E4D	RA	Referen Hardnes HRC	Avg.						
LB	Job No.: Detail No.: Part No.: 113980					KSI	KSI	%	%								
612				349	33	167	158	18	62								
Additional Testing																	
Capability Testing H900						Capability Testing H1075					Ferrite ASTM 2315						
	CAPTE	CAPYL	CAPEL	CAPRA	CAPHB					CAPTE	CAPYL	CAPEL	CAPRA	CAPHB	FERR		
	197	172	15	58	420					170	130	16	61	354	<5		
DAS 82 9-89																	
Country of manufacture: Italy Country of melt: France Macrostructure per ASTM E381: Pass										Material is free from mercury and radioactive contamination, welds or weld repairs at the time of shipment. DFARS 252.225-7009/7014 Compliant. Conforms to RoHS Directive 2002/95/EC and RoHS 2 2011/65/EC. Article contains no SVHC (REACH EC 1907/2006) The product supplied does not contain any Conflict Minerals as defined in Section 1502 of the "Dodd-Frank Wall Street Reform and Consumer Protection Act", and is 'Lead Free' in accordance with the Lead Free Law We certify that the material described has been tested complies with the terms of the order and test results are in accordance with the terms of the delivery agreed.							

IMR TEST LABS

A Curtiss-Wright Business Unit
www.imrtest.com

131 Woodsedge Drive
Lansing, NY 14882
T: 1.607.533.7000 | F: 1.607.533.9210

TEST REPORT

IMR Report Number 202011072

August 21, 2020

SUMMARY

Ray Tebo
Consolidated Precision
Products - Oriskany
100 Furnace Street
Oriskany, NY 13424

One sample was received for tensile testing.

The sample **meets** the tensile requirements of AMS 2759/3 Rev. J for a 17-4PH, condition H1150, precipitation-hardening, corrosion-resistant steel (form B, F, T, Bi, SSP and C).

The sample **meets** the tensile requirements as supplied by Consolidated Precision Products - Oriskany.

PO Number
TST12111JL

The results are below.

Date Received
August 17, 2020

TENSILE PROPERTIES - ROOM TEMPERATURE

Material
17-4PH

Condition
H1150

Specification(s)
AMS 2759/3 Rev. J
Customer Supplied Limits

	Tensile Strength (ksi)	Yield Strength (ksi)	Elongation (%)	Reduction of Area (%)
Sample	155	147	18	63
AMS 2759/3 Rev. J (B, F, T, Bi, SSP)	135 Min.	---	---	---
AMS 2759/3 Rev. J (C)	125 Min.	---	---	---
Customer Supplied Limits	135 Min.	105 Min.	---	---

The sample was machined to a diameter of 0.35 inches; gauge length was 1.40 inches. Yield strength was determined by the 0.2% offset method. Crosshead speed was 0.005 in./in./min. to yield and 0.4 in./min. to fracture. Method(s): ASTM E 8-16a



Reviewed by

Lisa M Wackowicz

Lisa Wackowicz
Technical Operations Coordinator

Reviewed by

Robert Southworth

Bob Southworth
Senior Mechanical Technician

All procedures were performed in accordance with the IMR Quality Manual, current revision, and related procedures; and the PWA MCL Manual F-23 and related procedures. The information contained in this test report represents only the material tested and may not be reproduced, except in full, without the written approval of IMR Test Labs ("IMR"). IMR maintains a quality system in compliance with the ISO/IEC 17025 and is accredited by A2LA, certificates #1140.01 and #1140.02. IMR will perform all testing in good faith using the proper procedures, trained personnel, and equipment to accomplish the testing required. Conformance will be based on results without measurement uncertainty applied, unless otherwise requested by the customer. IMR's liability to the customer or any third party is limited at all times to the amount charged for the services provided. All test samples will be retained for a minimum of 3 months and may be destroyed thereafter, unless otherwise specified by the customer. The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes. IMR Test Labs is a GEAE S-400 approved lab (Supplier Code 69805).

Consolidated Precision Products - Oriskany



CUSTOMER COPY 689266 *689266*

MURPHY & NOLAN INC SYRACUSE NY

Certificate of Compliance Required

Date Rec'd 08/11/2020 Customer Code UMUR Customer P.O. 769286-20P Delivered by UPSFED Material/Drawing 17-4PH H1150 Hardness HRC 28-37 Total Weight 4.15

Item	Qty.	Description	Part No.	Thk. (in.)	Weight
1	1	BAR 5/8" X 42"	113980		3.61
2	1	TENSILE BAR	NOT GIVEN		0.54

Notes:

GIVE TENSILE BAR TO QUALITY WHEN HT IS DONE.

HEAT# 639612

Inspection

1)RECEIVING(QCP:14,15,& 29) Contract Review performed by: C

2)INCOMING INSPECTION (QCP:4)

- A. Is count correct? ☒ Yes ☐ No
- B. Are parts clean and free of foreign objects? ☒ Yes ☐ No
- C. Are current specifications on file? ☒ Yes ☐ No
- D. Parts conform to customer paperwork? ☒ Yes ☐ No
- E. Initial: W

3)FINAL INSPECTION (QCP:4)

- A. Hardness tests taken at specified locations per an acceptable sampling program? ☒ Yes ☐ No
- B. Results within prescribed range? ☒ Yes ☐ No
- C. Parts been damaged in processing? ☒ Yes ☐ No
- D. Are parts clean and free of foreign objects? ☒ Yes ☐ No
- E. Is count correct? ☒ Yes ☐ No
- F. Initial: W

Hardness Verification

Pieces Checked: 1 Pes. Accepted: 1

Pieces Rejected: — Total Pieces: 1 + 1

Hardness Tester: N3 Hardness: 34/35 HRC

Checked by: W Date: 8/21/20

DAS
82
9-89



Murphy and Nolan, Inc.

STEEL TUBING · COLD FINISHED STEEL BARS · ALUMINUM · STAINLESS STEEL · DRILL RODS

Service in Metals Since 1953

55 Ind. Park Cir.
Rochester, NY 14624-2493
585-426-1420

Certificate of Compliance

Customer
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A1K7

Customer PO	Customer P/N	M&N Invoice #	Heat / Lot Number
POHB046867		769286-20	639612
Quantity	3		
Unit of Measure	FOOT		
Material Grade	17-4 PH PER AMS 5643 COLD FINISHED		
Shape	ROUND BAR		
Size	0.6250		

Mill size (if different from supplied size)

Part / bar length

Condition

Specification/Revision

Country of Origin

Additional Notes

DAS
82
9.89

Jonathan Coover (Approved M&N Operator) hereby certifies that material provided against this document complies with purchasers order requirements, unless otherwise noted, and is traceable to manufacturers heat/lot from shipment by manufacturer through delivery to purchaser. Verification of this statement is ~~performed per~~ Murphy and Nolan QMS procedures, certified to AS 9100D

Sign

Date

CofC Revised 8/20/2020

8-31-20

Murphy and Nolan, Inc.

STEEL TUBING • COLLYERIES STEEL BARS • ALUMINUM • STAINLESS STEEL • ORNAMENTAL ROD

Service in Metals Since 1953

55 Industrial Park Circle
Rochester, NY 14624-2493
(585) 426-1420 / (800)-**Delivery Receipt**

Page 1

09/01/2020
Loading: Open
Del Hrs: ALL DAY

Sold To	Ship To	Account
DART AEROSPACE 1270 ABERDEEN ST HAWKESBURY, ON K6A1K7 613-632-5200		020892 OS:006 ICAM:920 06:57:56 31 Aug 2020

Customer PO:		Mat Cert	Date Req'd	Shipping Point	F.O.B
 * P O H B 0 4 6 8 6 7 *		Yes	08/24/2020	Collect	Ship Point
Item	Quantity Ordered	Quantity Shipped*	U/M	Customer P/N	Heat Number

1 LG(S) (3#) 5/8" RD x 36.00" - 1/8" - 0.0000 CIL
STLS. STEEL ROUND BAR 17-4 PH PER AMS 5643 COLD FINISHED
Complete 3 FT

DAS
82
9-89**RECEIVED**

SEP 02 2020

DART AEROSPACE LTD.

SEE SALES FOR SHIPPING
INSTRUCTIONS ONCE READY1 Tube
Fedex: 7713 9935 2354

Packaging	Total Weight	Order Amount (\$)	Received By (Print Name and Date):
1 TUBE DESK	4	0.00	

P52, 10/11/17 (PRM)

*Final invoices are calculated using Quantity Shipped values.

Terms and conditions apply, please visit www.murphynolan.com for a complete listing of our terms and conditions.

Linda Lacelle

From: Carmine Marotta
Sent: Thursday, September 17, 2020 12:17 PM
To: Linda Lacelle
Cc: Nick Classen
Subject: RE: POHB047048 - ElectroPolish
Attachments: DART Aerospace82085.pdf

Hello,

Please see attached PO.

I have included both the part with the electropolish and the one without.

Regards,

Carmine Marotta
Purchasing Supervisor

SIMPLEX a company of
DART AEROSPACE
Direct: + 1-503-280-4460
Main: +1-503-257-3511
1 800 556- 4166
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From: Linda Lacelle <llacelle@dartaero.com>
Sent: Thursday, September 17, 2020 7:48 AM
To: Nick Classen <nklassen@dartaero.com>; Konrad Sauve <ksauve@dartaero.com>
Cc: Rick Williams <rwilliams@dartaero.com>; Carmine Marotta <cmarotta@dartaero.com>
Subject: RE: POHB047048 - ElectroPolish

Are we also shipping the ones that were electro polished? If so, we will need the order updated pls.

Thx
Linda

From: Nick Classen <nklassen@dartaero.com>
Sent: Thursday, September 17, 2020 10:46 AM
To: Konrad Sauve <ksauve@dartaero.com>
Cc: Rick Williams <rwilliams@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Carmine Marotta <cmarotta@dartaero.com>
Subject: RE: POHB047048 - ElectroPolish

Carmine,

Can you update PO# 82085 to exclude the electro-polish please.

Nick Classen

Director Of Operations - Portland

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Please note my email has changed.

From: Konrad Sauve <ksauve@dartaero.com>

Sent: Thursday, September 17, 2020 7:43 AM

To: Nick Classen <nklassen@dartaero.com>

Cc: Rick Williams <rwilliams@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>

Subject: RE: POHB047048 - ElectroPolish

Hey Nick could you ask your buyer to update the PO so that we can ship you the electro polished parts N-C.

Thanks,
Regards,
Konrad
514-892-5121

From: Nick Classen <nklassen@dartaero.com>

Sent: Tuesday, September 15, 2020 7:30 PM

To: Rick Williams <rwilliams@dartaero.com>

Cc: Konrad Sauve <ksauve@dartaero.com>

Subject: RE: POHB047048 - ElectroPolish

Konrad,

Send them here, we will take care of the plating.

Nick Classen

Director Of Operations - Portland

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From: Rick Williams <rwilliams@dartaero.com>
Sent: Tuesday, September 15, 2020 3:25 PM
To: Nick Classen <nklassen@dartaero.com>
Cc: Konrad Sauve <ksauve@dartaero.com>
Subject: RE: POHB047048 - ElectroPolish

It's hard to tell the level of damage from the pics and if it's etching or just a missed spot. Maybe we should get both the finished and unfinished parts here to evaluate them. I don't recall seeing anything like that before that wasn't heat treating etching.

\$.02

Rick Williams
Quality Assurance Supervisor / FAA DMIR

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From: Nick Classen <nklassen@dartaero.com>
Sent: Tuesday, September 15, 2020 2:26 PM
To: Rick Williams <rwilliams@dartaero.com>
Cc: Konrad Sauve <ksauve@dartaero.com>
Subject: FW: POHB047048 - ElectroPolish

Rick,

Any issues accepting these? Electropolish has imperfections, I assume they hang from those spots. I wonder if the Spec has that same 5% imperfection clause the anodizing has.

Nick Classen
Director Of Operations - Portland

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From: Konrad Sauve <ksauve@dartaero.com>
Sent: Tuesday, September 15, 2020 1:36 PM
To: Nick Classen <nklassen@dartaero.com>
Subject: FW: POHB047048 - ElectroPolish

Take a look these are the one that were rejected and according to our vendor this is the best he can do, that being said can I send you another set that is raw finish and you have it done by your vendor?

Thank you,
Konrad

From: Kimberley Guerin <kguerin@dartaero.com>
Sent: Tuesday, September 15, 2020 4:32 PM
To: Konrad Sauve <ksauve@dartaero.com>
Subject: FW: POHB047048 - ElectroPolish

From: Deepak sharma <inspection@groupaltech.com>
Sent: Tuesday, September 15, 2020 8:58 AM
To: Kimberley Guerin <kguerin@dartaero.com>
Cc: 'Jessie Boisvert' <csr@groupaltech.com>
Subject: RE: POHB047048 - ElectroPolish

Hi Kim Good Morning,

There is no place to hang these parts , there will be some racking marks from where we holded the parts.

Even if we redo them there will be some mark!!

You can send them back to my attention , We will try one more time.

Merci / Thank you,

Deepak Sharma
Quality Assurance Engineer,
2455 Halpern,
St-Laurent, QC,
H4S 1N9
Tel: (514) 335-3666 Ext: 131
Fax: (514) 335-3868
Inspection@groupaltech.com
www.groupaltech.com



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From: Kimberley Guerin [<mailto:kguerin@dartaero.com>]

Sent: Tuesday, September 15, 2020 8:39 AM

To: Deepak sharma

Subject: POHB047048 - ElectroPolish

Good Morning Deepak,

We received these parts back yesterday and there are markings on each piece. These are not acceptable.

What are our options with ElectroPolish – can they be stripped and re-done?

Thanks,

Kim Guerin

Buyer

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Part No	Part Name	Primary Air Sales Lead	On Order	C	BSD	Min Inv Qty	On Hand	Q	WIP Qty	Broussard current stock	Need to make
D119-796-101	Fwd Crosstube Installation With Step	AW119 6 weeks	0			1	0	0	0	0	1
D119-796-201	Aft Crosstube Installation With Step	AW119 6 weeks	0			1	0	0	0	0	1
D139-1019-013	AW139 Skylight Window, Bronze - LH	AW139	0			2	0	0	0	0	2
D206-628-034	Heli-Access-Step™ RH - High Gear, Float Compatible 407	Bell Light/C 4 weeks	0			1	0	0	0	0	1
D206-642-511	Skidtube LH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Comp.	Bell Light/C 4 weeks	0			3	2	0	0	2	1
										0- x1 in wip because of damage in transit to Broussard - OH212277	
D206-642-512	Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Comp.	Bell Light/C 4 weeks	0			3	0	1	0	1	1
D139-1019-014	AW139 Skylight Window, Bronze - RH	AW139	0			2	0	0	0	0	2
D407-667-105	Fwd Crosstube - High 407	Bell Light/C 3.5 weeks	0			2	1	0	0	1	1
D407-667-205	Aft Crosstube - High 407	Bell Light/C 3.5 weeks	0			2	0	1	1	0	2